

Date: Thursday, 23/04/2009 3:32:58 PM
 User: Julie Dawson

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	CHAFING SHIELD
Job Number :	47456		
Estimate Number :	11138		
P.O. Number :		Part Number :	D31901
This Issue :	23/04/2009	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D3190 REV A
First Issue :	//	Project Number :	N/A
Previous Run :	40109	Drawing Revision :	A
Written By :		Material :	
Checked & Approved By :	<u>JUD 09-04-24</u>	Due Date :	30/04/2009
Comment :	Est. A 03.05.26 New issue KJ/RF	Qty:	20 Um: Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S25GA	304/316 .020" Sheet
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Comment: Qty.: 0.2261 sf(s)/Unit Total : 4.5213 sf(s)

304/316 SS .020" Sheet

Material: AISI 304/316 SS 0.020" thick sheet
 (M304S25GA)

Batch: M107436

M107436

M107513

2.0	SHEAR	SHEAR
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Comment: SHEAR

Cut blank: 9.25" x 3.13"

Grind corner as per Dwg D3190

Deburr

Roll as per Dwg D3190

3.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

4.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: LG

m/ 09-04-28

20

5.0	QC21	FINAL INSPECTION/W/O RELEASE
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Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



m/ 09-04-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

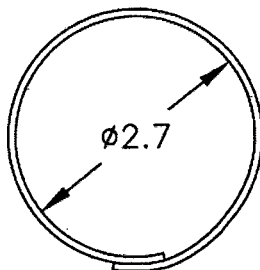
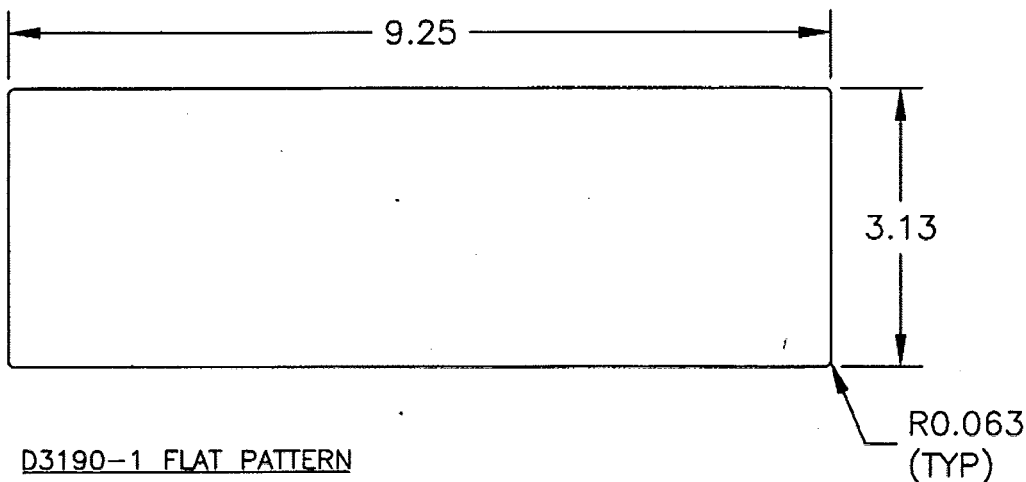
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN #	DRAWN BY UP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3190	REV. A SHEET 1 OF 1
DATE 03.05.16		TITLE CHAFING SHIELD	SCALE 1:2
A	03.05.16	NEW ISSUE	

RELEASED
03.05.22 #



D3190-1 ROLLING DETAIL
NOT TO SCALE

D3190-1 CHAFING SHIELD

- 1) MATERIAL: AISI 304/316 SS 0.020" THICK (REF. DART SPEC M304S25GA)
- 2) FINISH: NONE
- 3) DEBURR/BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

SHOP COPY
RETURN TO
ENGINEERING
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 47456

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